

Work Order ID 141433

Friday, February 05, 2016 7:32:33 AM

141433

Page 1

Item ID: D4092-1

Revision ID:

Item Name: Maintenance Step

Start Date: 2/3/2016 Start Qty: 8.00

Required Date: 2/3/2016 Req'd Qty: 8.00

Reference:

Accept

N900040100

Setup Start ***NS1***

Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan: MLJ Date: FEB 05 2016 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4092	C

100	Cut blanks as per folio	0.00
-----	-------------------------	------

100

Bandsaw

Jeaspa Bandsaw

Memo

0.00

110

110

HAAS 1

HAAS CNC vertical machine #1

Memo

Mill as per Dwg and Folio FA935

Dwg Rev: C

Folio rev: AA

Deburr

0.02

0.04

****Grind flush transition machining mark after machining bottom of extrusion, see detail A.****

21

Ø

21

Ø

DAS
20
9-89

16-03-12

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Work Order ID 141433

Friday, February 05, 2016 7:32:33 AM

141433

Page 3

Item ID: D4092-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Maintenance Step

Stop

NS2

Start Date: 2/3/2016 Start Qty: 8.00

8

Cust Item ID:

Required Date: 2/3/2016 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

155

Wing Walk as per dwg OSI005 4.4 Batch 14321700***155***

HandFinish

Memo

0.02

Hand Finishing

x21 6 16/03/15

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

(21)DAS
38
9-89

MAR 15 2016

170

Identify as per dwg & Stock Location: 51450

0.00

170

Packaging

Memo

0.00

Packaging

21 16/3/15 SD

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QS1042) Approval	
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
Equip/Tooling ☐	☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐			
Handling/Pre ☐	☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Material ☐	☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐			
Internal Transport ☐	☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐			
Tribal Knowledge ☐	☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐			
LOA ☐	☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐			
Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER : _____						
Misidentified ☐	☐	Past Due ☐							

Work Order ID 141433

Friday, February 05, 2016 7:32:33 AM

141433

Page 4

Item ID: D4092-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Maintenance Step
Start Date: 2/3/2016 Start Qty: 8.00 ***8*** Cust Item ID:
Required Date: 2/3/2016 Req'd Qty: 8.00 ***8*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.01							
Quality Control									

MCS MAR 15 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐				
Date :	Step #:	QTY Effective :			MRB (QSI042) Approval	
Description Work Order Deviation		Disposition				
					Completed By	
					Lead hand / Supervisor Approval Verification	
					QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
OTHER : ☐						

Picklist Print

Friday, February 05, 2016 7:32:35 AM

Page 1

Work Order ID: 141433

141433

Parent Item: D4092-1

D4092-1

Parent Item Name: Maintenance Step

Start Date: 2/3/2016

Required Date: 2/3/2016

Start Qty: 8.00

Required Qty: 8.00

Comments: Ipp Rev:A New Issue 10-05-31 JLM Verified By:DD
REV:B AS PER ECN 11-639 JLM VERIFIED BY:DD

IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2761-108		Manufactured	No			100	f	76.5890	2.5	21.05263			

D2761-108

Extrusion (HPK)

Location

Loc Qty

Loc Code

MAT051

76.589

80206

76.589

72.589

mf
16/03/10

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

DART AEROSPACE LTD		Work Order:	141433
Description: Maintenance Step		Part Number:	D4092-1
Inspection Dwg: D4092	Rev: C	Page 1 of 1	

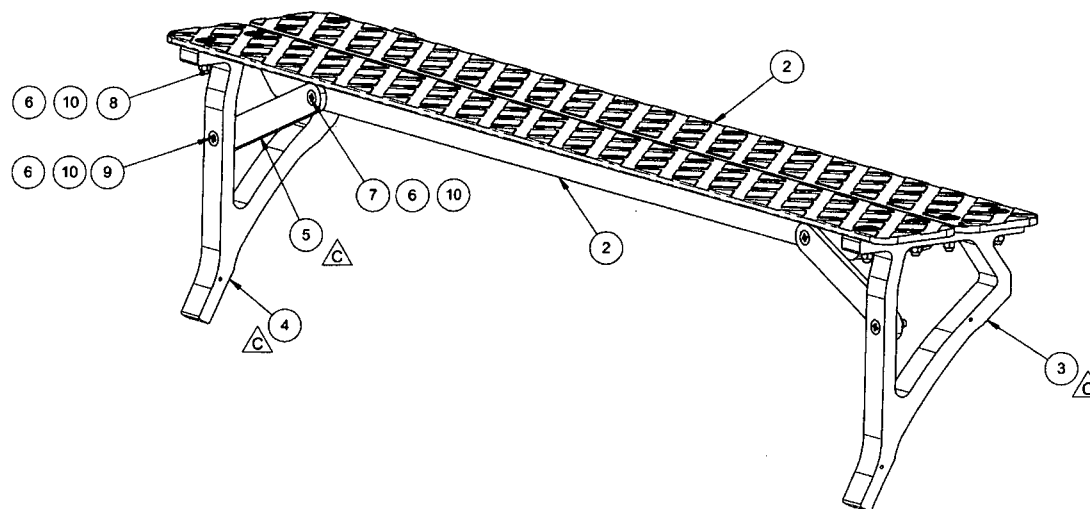
INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
30.06	+/-0.030	30.06	✓		MJP-07	Tape
0.19	+/-0.030	0.184	✓		MJP-04	vern
1.25	+/-0.030	1.245	✓		...	...
1.38	+/-0.030	1.367	✓			
0.25	+/-0.030	0.246	✓			
R0.25	+/-0.030	0.250	✓		—	Radius gauge
2.50	+/-0.030	2.497	✓		MJP-04	vern
Ø0.201	+0.005/-0.001	0.202	✓		...	...
0.30	+/-0.030	0.300	✓			
4.78	+/-0.030	4.777	✓			
1.69	+/-0.030	1.690	✓			
2.96	+/-0.030	2.960	✓			
0.030	+/-0.010	0.030	✓			
0.20	+/-0.030	0.200	✓			
0.50	+/-0.030	0.500	✓			
0.035	+/-0.010	0.030	✓			
0.390 x 100°	+/-0.010 x 0.5°	0.390 x 100°	✓			
1.500	+/-0.130	1.500	✓			
0.50	+/-0.030	0.500	✓			
1.25	+/-0.030	1.247	✓			
0.69	+/-0.030	0.690	✓			
0.38	+/-0.030	0.380	✓			
0.69	+/-0.030	0.690	✓			

Measured by: <i>G.P.</i>	Checked by: <i>G.P.</i>	DAS 08 9-89	QC Inspector:
Date: 16/03/11	Date: 16/03/13		Date:

Engineering Approval: (If necessary)	Date:
--	--------------

Rev	Date	Change	Revised by	Approved
A	12.05.15	New Issue	KJ	
B	13.06.18	Dimension 2.96 was 2.69	KJ	
C	15.11.19	Dwg Rev updated	KJ	<i>[Signature]</i>



D4092-041 MAINTENANCE STEP ASSEMBLY

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D4092-041	MAINTENANCE STEP ASSEMBLY
2	2	D4092-1	MAINTENANCE STEP
3	1	D4093-1	BRACKET
4	1	D4093-3	BRACKET
5	2	D4093-5	BRACE
6	12	MS21042L3	NUT, SELF-LOCKING
7	2	MS24694-S54	SCREW, CSK 100*
8	8	MS24694-S55	SCREW, CSK 100*
9	2	MS24694-S56	SCREW, CSK 100*
10	12	NAS1149D0332J	WASHER

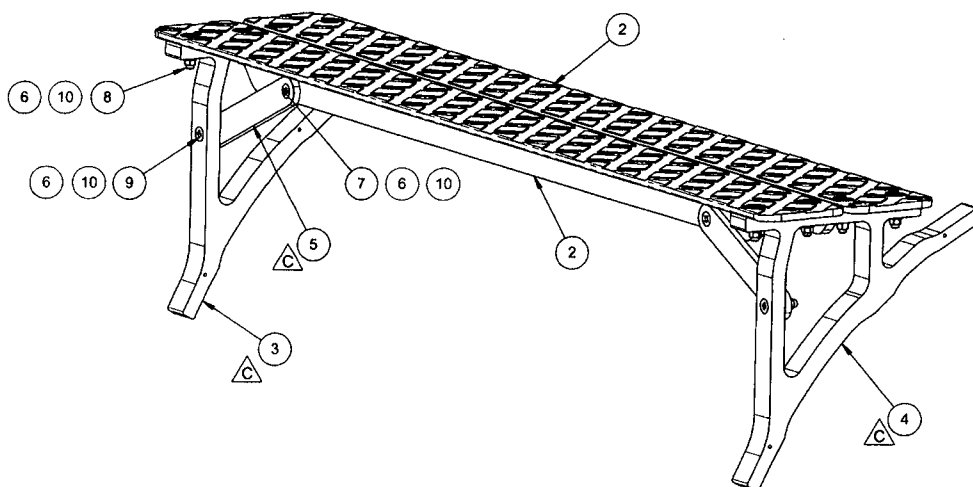
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 141433MWS
16-02-05

RELEASED
2015-09-21
ECN 15-556

C	REVISE DIMENSION; ZN D5-5, D8-5, B3-6, ADD BALLOONS; ZN B3-1, C6-1, B7-1, C6-2, B6-2, B4-2	VS	15.03.09
B	REDRAWN; LOWERED FOR AESTHETICS	RF	11.07.27
A	NEW ISSUE	RF	10.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	VS	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	VS		
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	JLM	D4092	SHEET 1 OF 6
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	MAINTENANCE STEP ASSY	NTS
DATE	15.03.09	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

APPROVED

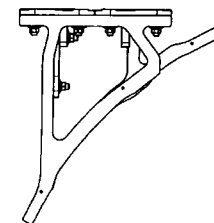
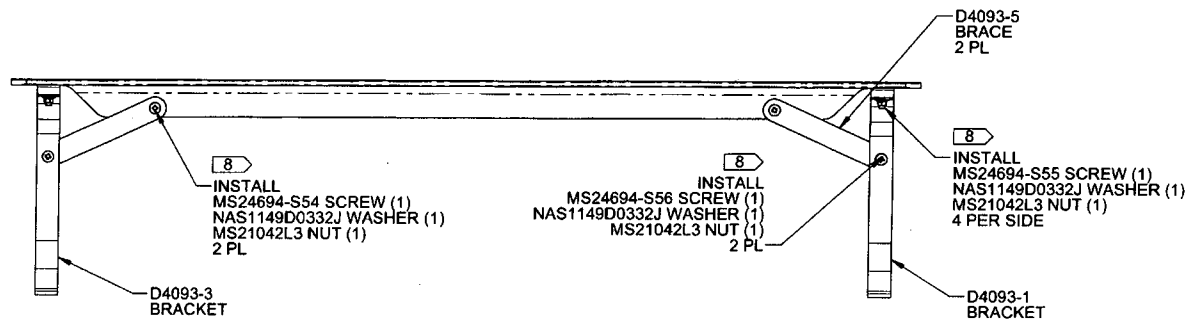
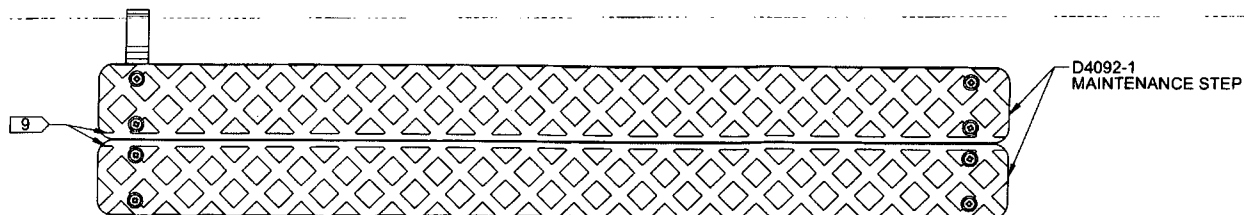
ITEM	QTY -042	P/N	DESCRIPTION
1	X	D4092-042	MAINTENANCE STEP ASSEMBLY
2	2	D4092-1	MAINTENANCE STEP
3	1	D4093-1	BRACKET
4	1	D4093-3	BRACKET
5	2	D4093-5	BRACKET
6	12	MS21042L3	NUT, SELF-LOCKING
7	2	MS24694-S54	SCREW, CSK 100°
8	8	MS24694-S55	SCREW, CSK 100°
9	2	MS24694-S56	SCREW, CSK 100°
10	12	NAS1149D0332J	WASHER



D4092-042 MAINTENANCE STEP ASSEMBLY

RELEASED
2015-09-21

APPROVED	DESIGN	VS	DART AEROSPACE USA, INC. KENT, WA	
	DRAWN	VS		
	CHECKED	RF	DRAWING NO.	REV. C
	MFG. APPR.	JLM	D4092	SHEET 2 OF 6
	APPROVED	HS	TITLE	SCALE
DE APPR.	DS	MAINTENANCE STEP ASS'Y	NTS	
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D4092-041 MAINTENANCE STEP ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 5.28 lbs
- 8) TORQUE SCREWS UP TO 15-25 in-lb (1.7-2.8 N-m)
- 9) GRIP CUTOUT TOWARD CENTER

RELEASED
2015-09-21

APPROVED

DESIGN
DRAWN
CHECKED
MFG. APPR.
APPROVED
DE APPR.
DATE

VS
VS
RF
JLM
HS
DS

15.03.09

DART AEROSPACE USA, INC.
KENT, WA

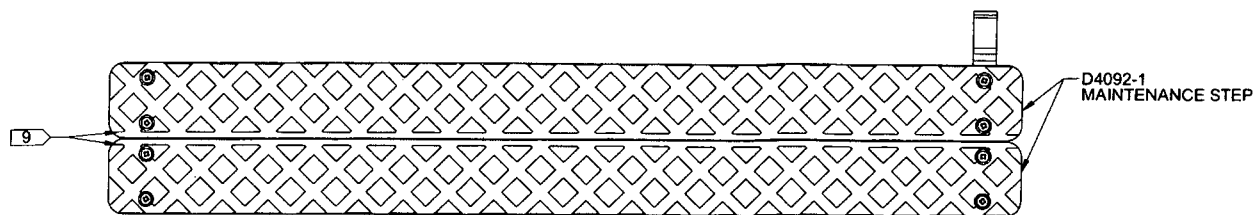
DRAWING NO.
D4092

REV. C
SHEET 3 OF 6

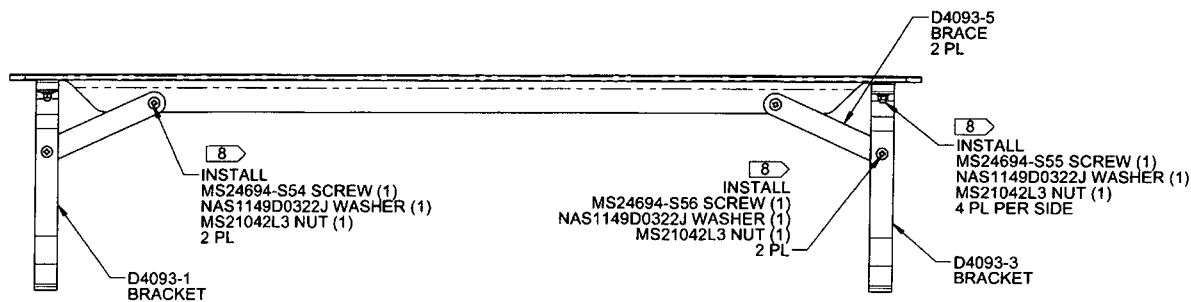
TITLE
MAINTENANCE STEP ASS'Y

SCALE
NTS

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D4092-1
MAINTENANCE STEP



8
INSTALL
MS24694-S54 SCREW (1)
NAS1149D0322J WASHER (1)
MS21042L3 NUT (1)
2 PL

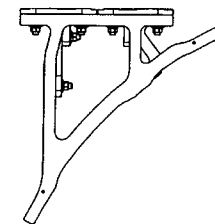
D4093-1
BRACKET

8
INSTALL
MS24694-S56 SCREW (1)
NAS1149D0322J WASHER (1)
MS21042L3 NUT (1)
2 PL

D4093-5
BRACE
2 PL

8
INSTALL
MS24694-S55 SCREW (1)
NAS1149D0322J WASHER (1)
MS21042L3 NUT (1)
4 PL PER SIDE

D4093-3
BRACKET



D4092-042 MAINTENANCE STEP ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 5.28 lbs
- 8) TORQUE SCREWS UP TO 15-25 in-lb (1.7-2.8 N-m)
- 9) GRIP CUTOUT TOWARD CENTER

RELEASED
2015-09-21

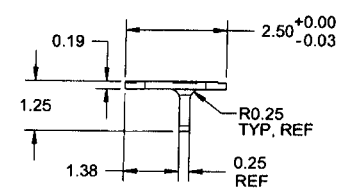
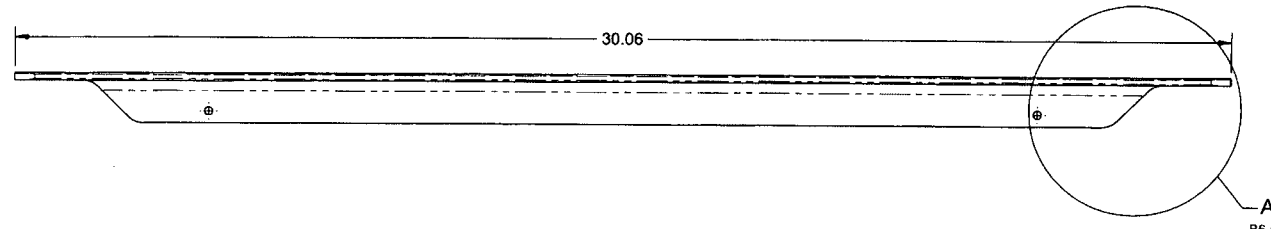
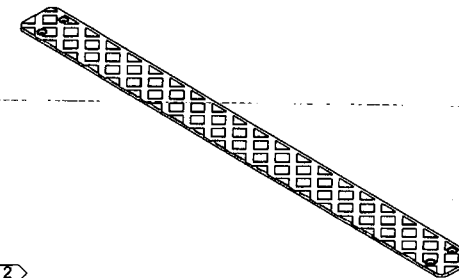
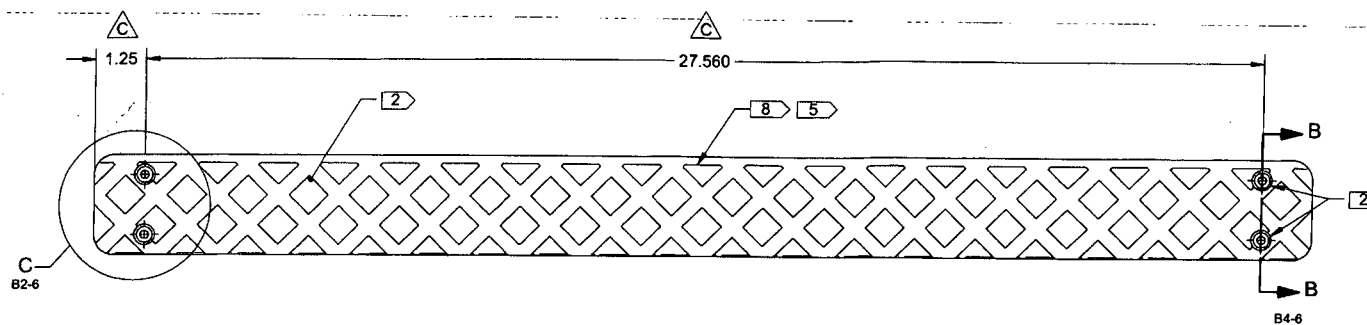
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DESIGN	VS
DRAWN	VS
CHECKED	RF
MFG. APPR.	JLM
APPROVED	HS
DE APPR.	DS
DATE	15.03.09

DART AEROSPACE USA, INC.
KENT, WA

DRAWING NO.
D4092
REV. C
SHEET 4 OF 6
TITLE
MAINTENANCE STEP ASS'Y
SCALE
NTS

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D4092-1 MAINTENANCE STEP
(MAKE FROM D2761 EXTRUSION)

NOTES:

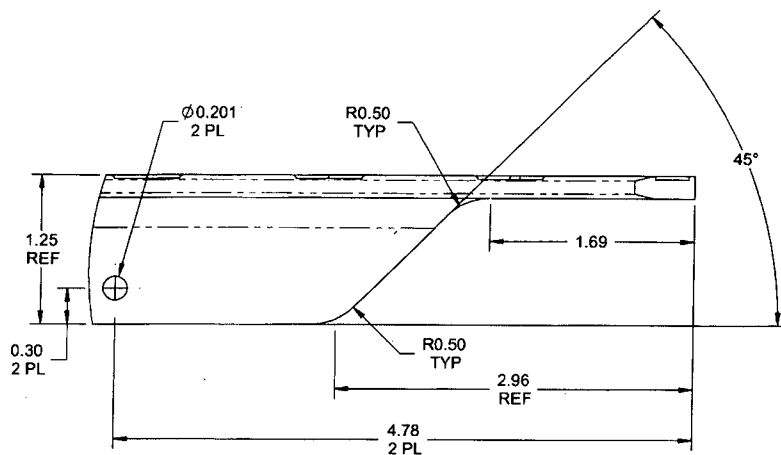
- 1) MATERIAL: MAKE FROM D2761 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
BLACK ANTI-SKID PAINT GRIP AREA AS INDICATED PER DART QSI 005 4.4
MASK RECTANGULAR CUTOUT PRIOR TO APPLICATION OF ANTI-SKID
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX, NOT REQUIRED TO DEBURR GRIP AREA
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.97 lbs
- 8) MACHINE 0.69 x 0.69 GRIP 0.030 DEEP AT 45° PATTERN 0.38 APART

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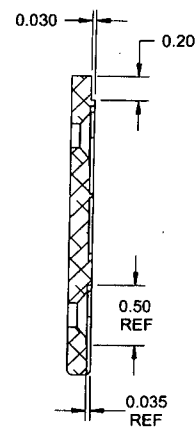
DESIGN	VS
DRAWN	VS
CHECKED	RF
MFG. APPR.	JLM
APPROVED	HS
DE APPR.	DS
DATE	15.03.09

DART AEROSPACE USA, INC.	
KENT, WA	
DRAWING NO.	REV. C
D4092	SHEET 5 OF 6
TITLE	SCALE
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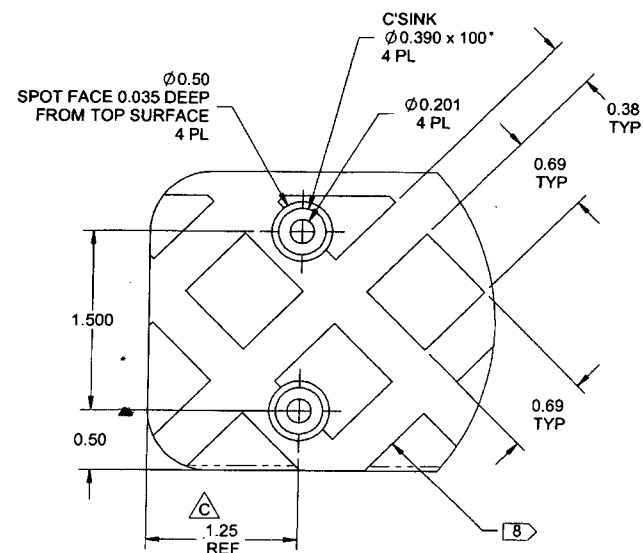
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DETAIL A B3-5
SCALE 3X, TYP



SECTION B-B C3-5
SCALE 3X, TYP



DETAIL C C8-5
SCALE 3X, TYP

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MFG. APPR. JLM	SHEET 6 OF 6		SCALE
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DE APPR. DS	MAINTENANCE STEP ASSY		
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